

Work Order ID 61782

Friday, September 03, 2010 10:11:42 AM



Page 1

Item ID: D3908-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Aft

Start Date: 9/3/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 10-9-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3908

C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

E 5/10/05 @

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg
TRIM RIVETS 1.185" LONG

E 5/10/05 @

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sialolol

(x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61782

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Page 2

Item ID: D3908-041**Accept****Setup Start****Revision ID:****Stop****Item Name:** Crosstube Lug Assembly, Aft**Start Date:** 9/3/2010 **Start Qty:** 6.00**Cust Item ID:****Required Date:** 9/13/2010 **Req'd Qty:** 6.00**Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

130

Identify as per dwg & Stock Location: S10

0.00



Packaging

Memo

0.00

Packaging

10/10/06 SD (60)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/06 JG
MF
10-10-06

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NOTE: Date & initial all entries




Friday, September 03, 2010 10:11:48 AM

Parent Item Name: Crosstube Lug Assembly, Aft

Required Date: 9/13/2010

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
As per Rev B 10-04-06 VERIFIED BY:DD
10.05.27 DD verf:EC
10.05.28 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6  Lanyard Assembly		Manufactured	No			100	Each	31.0000	1	6			
				<u>Location</u>									
				ST020				31					
				59960				6					
				61382				25					
D3908-1  Lug Plate, Aft Crosstube		Manufactured	No			100	Each	15.0000	2	12			
				<u>Location</u>									
				ST094				10					
				60035				10					
				ST095				5					
				58344				5					
D3908-3  Stud Receiver, Lower		Manufactured	No			100	Each	20.0000	1	6			
				<u>Location</u>									
				ST095				20					
				57816				2					
				58849				1					
				59453				7					
				60228				10					

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Friday, September 03, 2010 10:11:48 AM

Page 2

Work Order ID: 61782

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 9/3/2010

Required Date: 9/13/2010

Start Qty: 6.00

Required Qty: 6.00

D3908-5 Manufactured No

100 Each

15.0000

1

6



Eyebolt Stud

Location

Loc Qty

Loc Code

GA

1

57428

1

ST095

14

58850

4

59670

10



EP 10/10/06

D3910-1 Manufactured No

100 Each

9.0000

1

6



Crosstube Lug

Location

Loc Qty

Loc Code

st507

9

59349

8

59708

1



EP 10/10/06

D4091-1 Manufactured No

100 Each

5.0000

1

6



Mounting Lug

Location

Loc Qty

Loc Code

ST460

5

61008

5



EP 10/10/06
84 664993 (2x)

AN3C12A Purchased No

100 Each

66.0000

2

12



Bolts

Location

Loc Qty

Loc Code

ST351

66

112314

8

114761

11

115392

47



EP 10/10/06
12

Friday, September 03, 2010 10:11:49 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Page 3

Work Order ID: 61782

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 9/3/2010

Required Date: 9/13/2010

Start Qty: 6.00

Required Qty: 6.00

AN4C13A Purchased No 100 Each 91.0000 1 6
BOLT

Location	Loc Qty	Loc Code
ST357	91	
113359	3	
114442	38	
114615	50	

MS17984-C413 Purchased No 100 Each 18.0000 1 6
PIN, QUICK RELEASE

Location	Loc Qty	Loc Code
ST297	4	
114340	4	
ST314	14	
114523	1	
114886	13	

MB
MS20615-4M20 Purchased No 100 Each 266.0000 6 36
RIVET

Location	Loc Qty	Loc Code
ST323	266	
114808	96	
115054	170	

M115037

Friday, September 03, 2010 10:11:49 AM

Shop Packet Print

Page 3

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Page 4

Work Order ID: 61782

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 9/3/2010

Required Date: 9/13/2010

Start Qty: 6.00

Required Qty: 6.00

MS21043-3
Purchased
No
Nut



100 Each

2,672.000

2

12



EP 5.0/10/05

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2596

109147

4

111383

46

112314

2546

MS21043-4
Purchased
No
Nut



100 Each

857.0000

1

6



EP 5.0/10/05

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

817

112492

25

113069

8

114523

484

114784

300

NAS1149C0332R
Purchased
No
Washer



100 Each

871.0000

4

24



EP 5.0/10/05

Location

Loc Qty

Loc Code

ST297

871

113524

10

113737

150

114341

26

115000

685

1115816 (242)

Friday, September 03, 2010 10:11:49 AM

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Page 4

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 5

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Work Order ID: 61782



Parent Item: D3908-041



Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 9/3/2010

Required Date: 9/13/2010

Start Qty: 6.00

Required Qty: 6.00

NAS1149C0432R

Purchased

No

100

Each

682.0000

2

12



Washer

EPB 10/10/05
12

Location

Loc Qty

Loc Code

ST297

682

114292

92

114742

590

Friday, September 03, 2010 10:11:49 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

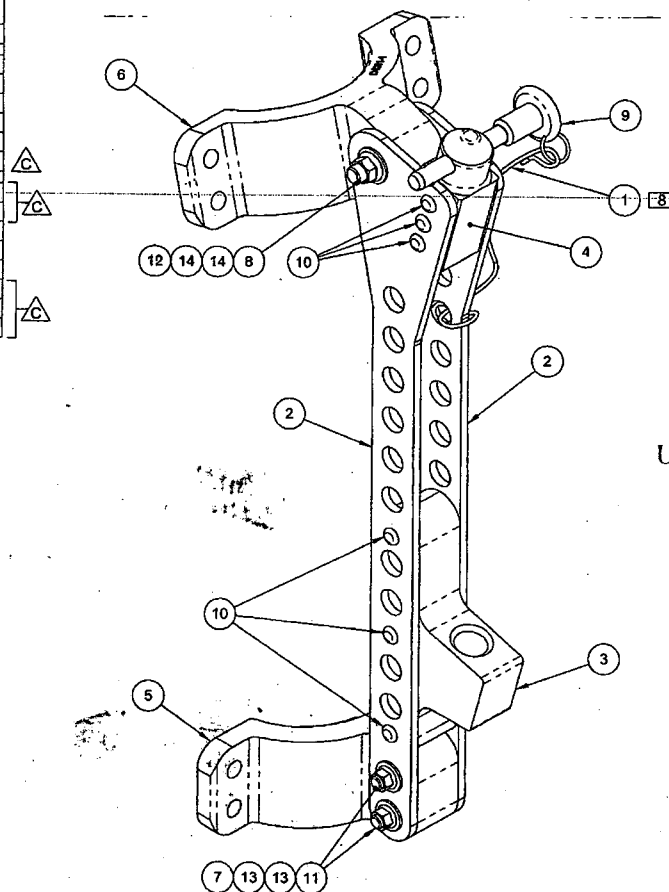
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NOTE: Date & initial all entries

ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	1	D3910-1	X-TUBE LUG
6	1	D4091-1	MOUNTING LUG
7	2	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	6	MS20815-4M20	RIVET
11	2	MS21043-3	NUT
12	1	MS21043-4	NUT
13	4	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER



D3908-041 X-TUBE LUG ASSY (AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.34 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61782

RP10-9-02

RELEASED
2010-05-28
AW

C	REDESIGNED ITEM #2; ITEM#6 REPLACES QTY 1 ITEM#5; QTY 2 FOR ITEMS #7 & 11 WAS QTY 4, QTY 8 FOR ITEM #13 WAS 4, ADDED ITEMS #8, 12 & 14	MB	10.05.27
B	BOM: D3909-5 REPLACED WITH D3908-5, QTY 1 ADDED: D2690-6 & MS17984-C413, SHEET 5: ADDED D3908-5	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.05.27		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3908
REV. C
SHEET 1 OF 5
TITLE
X-TUBE LUG ASSY (AFT)
SCALE
NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

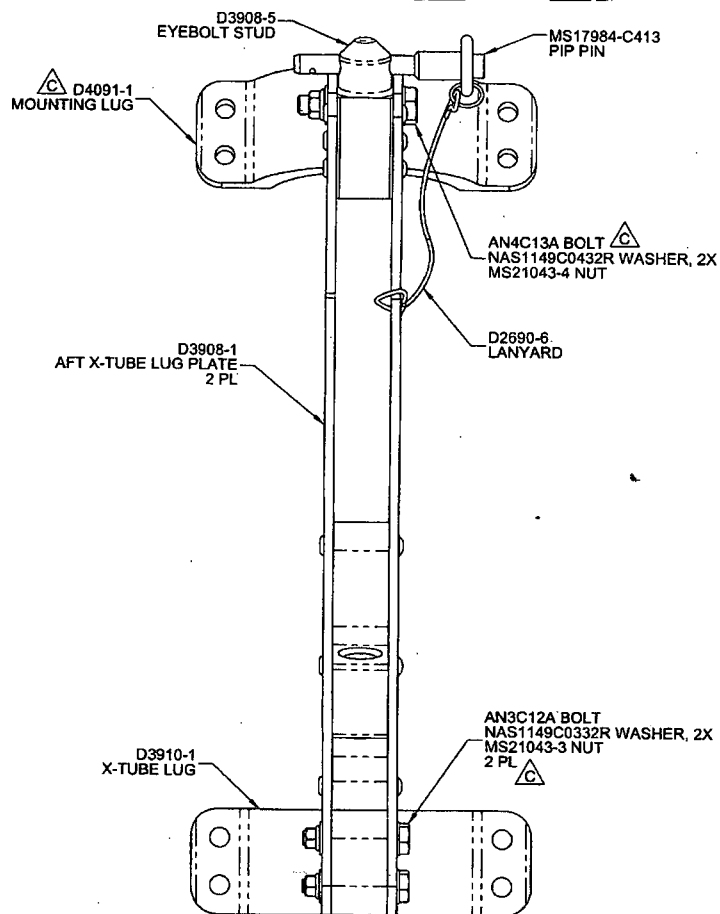
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



w/o 41782

RELEASED
2010-05-28
JMP

D3908-041 X-TUBE LUG ASSY (AFT)

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

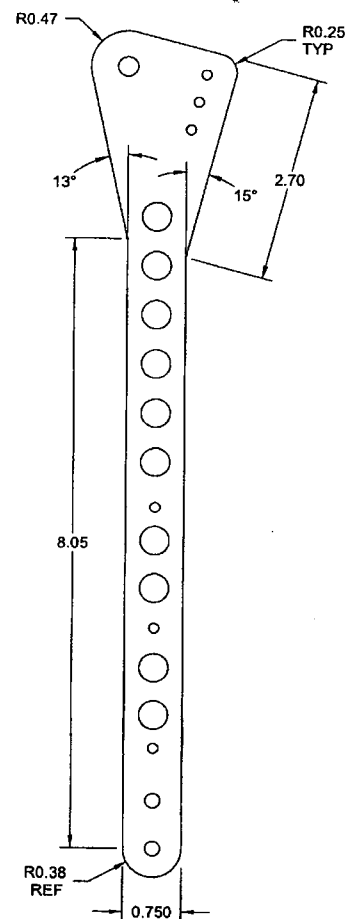
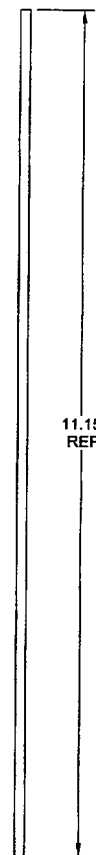
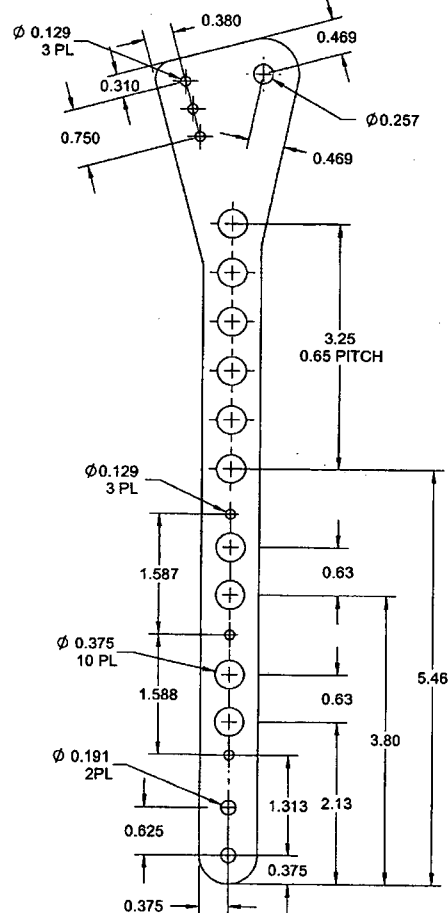
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NOTE: Date & initial all entries



w/o 4782

RELEASED
2010-05-28
WJ

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.31 lbs

D3908-1 AFT X-TUBE LUG PLATE

DESIGN	JFH	DART AEROSPACE LTD	REV. C
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3908	SHEET 3 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		X-TUBE LUG ASSY (AFT)	NTS
DE APPR.		COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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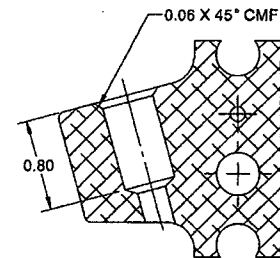
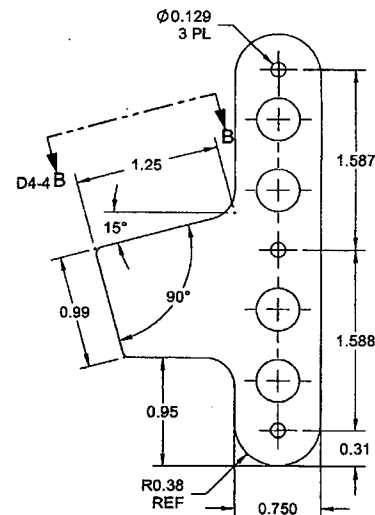
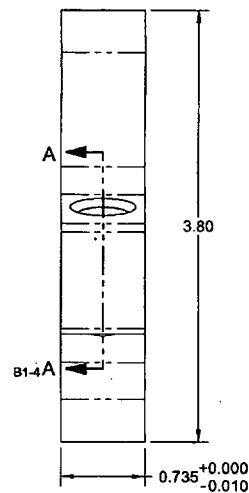
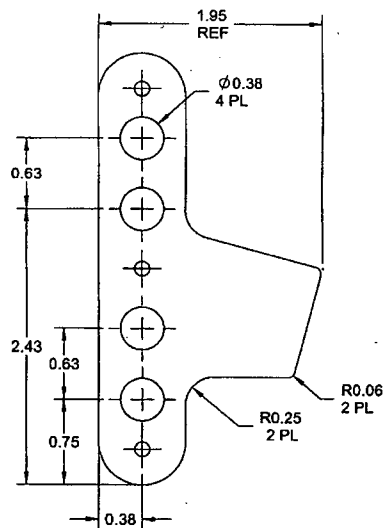
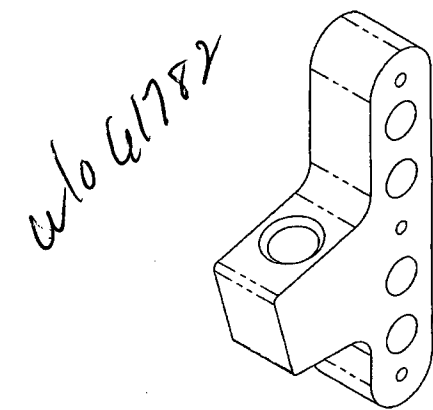
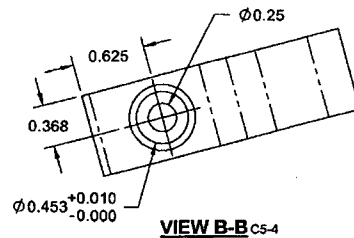
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3908-3 STUD RECEIVER LOWER

RELEASED
2010-05-28

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.69 lbs

DESIGN	JFH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3908	SHEET 4 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		X-TUBE LUG ASSY (AFT)	NTS
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DATE	10.05.27		

8 7 6 5 4 3 2 1

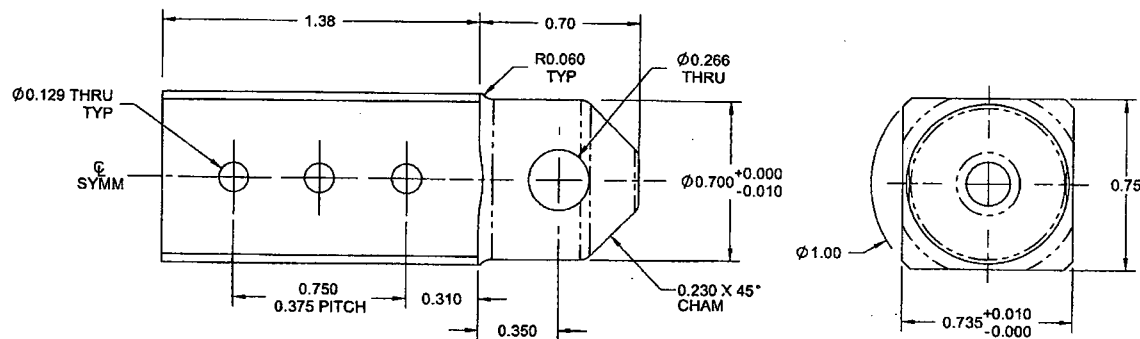
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NOTE: Date & initial all entries





D3908-5 EYEBOLT STUD

RELEASED
2010-05-28
MP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
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